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D4165-1

Job Sheet 204703



Part No: D4165-1

Job Qty: 6 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/18/19

Job Tracking No:

Due Date: 1/30/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B SHEET 1 IPP Rev:A 11.03.09 new issue DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs		1/30/20	0.02	0.88	Waterjet - Flow		de 20/01/13
120	QC 8	6 pcs		1/30/20	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		JAN 13 2020 68
							QC 8 - 67		9-89
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
130	Handfinish - 1-1 Chemical-B4B	6 pcs		1/30/20	0.00	0.45	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		

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				Handfinish - 1 - 3 - B4B	JAN 14 2020
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
135	QC 7	6	1/30/20	QC 7 - 10	DAS 40 9-89 JAN 14 2020
		pcs	0.00 0.00	QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	JAN 14 2020
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	

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					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
140	Packaging 3-1 - Stock - B4B	6 pcs	1/30/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	DAS 74 JAN 14 2020
					Packaging 3 - 5 - B4B	9-89
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
150	QC 21 - SA	6 pcs	1/30/20	0.00 0.00	QC 21 - SA - 21	DAS 21 9-89 JAN 14 2020
					QC 21 - SA - 70	
					QC 21 - SA - 53	
Part Op 120 - (QC8- Inspect parts - second check) Descriptions: 130 - (Chemical Conversion Coat per QSI005 4.1) 135 - (QC7-Inspect Chemical Conversion Coat) 140 - (Identify as per dwg & Stock Location: _____) 150 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
M2024T3S.040	2024-T3 .040 Sheet	2.1180 sf (.353 ea)	100-Waterjet - Flow - 1	S216342		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Waterjet - Flow - 1	M2024T3S.040	2	174	0		

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	5.340Inches ± 0.030	5.370 5.310		
2	Doubler	3.050Inches ± 0.030	3.080 3.020		
3	Doubler	1.090Inches ± 0.030	1.120 1.060		
4	Doubler	4.800Inches ± 0.030	4.830 4.770		
5	Doubler	7.750Inches ± 0.030	7.780 7.720		
6	Doubler	0.580Inches ± 0.030	0.610 0.550		
7	Doubler	0.630Inches ± 0.030	0.660 0.600		
8	Doubler	5.850Inches ± 0.030	5.880 5.820		
9	Doubler	4.000Inches ± 0.030	4.030 3.970		
10	Doubler	5.030Inches ± 0.030	5.060 5.000		
11	Doubler	0.040Inches ± 0.010	0.050 0.030		

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____		DISPOSITION		DEPARTMENT/PROCESS	
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause		FAULT CATEGORY			
Operator ☐		Contamination ☐		Power Loss/Surge ☐	
Manufacturing Process ☐		Misaligned/off center ☐		Folio/Program ☐	
Equip/Tooling ☐		BOM/Route ☐		Grain Direction ☐	
Handling/Preservation ☐		Broken/Damage/Defect ☐		Weld ☐	
Material ☐		Incomplete/Unclear Instructions ☐		Wrong Stock Pulled ☐	
Product Improvement ☐		Drill Holes ☐		Out of Sequence ☐	
Process Improvement ☐		Fit/Function ☐		Off-set/Set-up ☐	
Human Factors ☐		Other/Details: _____		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	